

Date: Monday, 1/16/2006 4:19:42 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLEVIS
Job Number	: 25530		
Estimate Number	: 10578		
P.O. Number	: N/A	Part Number	: D34533
This Issue	: 1/16/2006 S.O. No. : N/A	Drawing Number	: D3453 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 24971	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 1/23/2006 Qty: 2 Um: Each
Checked & Approved By	: <u>SEE COMMENT BELOW</u>		
Comment	: A 05.09.27 New issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R1250	Inventory
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Comment: Qty.: 0.2452 f(s)/Unit Total : 0.4904 f(s)
 Material: AISI 304 SS Round Bar Ø1.250
 (M304R1.250)
 Batch: M16889

ml 06/01/21

3

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 1-Turn as per Folio FA578 Rev: N/A & Dwg D3453 Rev: A
 2- Deburr as per dwg D3453

ml 06/01/21

3

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/01/21

3

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-Mill as per Folio FA578 Rev: N/A & Dwg D3453 Rev: A (done manually) *ml 06/01/22*
 2- Deburr as per dwg 3453 *ml 06/01/22*

3

3

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/01/22 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/16/2006 4:19:42 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 25530

Part Number: D34533

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Drill as per dwg D3453

2-Deburr as per dwg D3453

ml 06/01/22

3

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/01/22

3

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

M8 06/01/23

3

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *427*

06/01/23

(3)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Sur 06/01/24 (3)

(3) 06/01/24

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: PD Date: 04/01/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

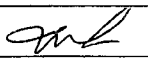
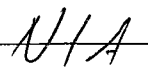
NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25530
Description: CLEVIS	Part Number:	P D 3453-2
Inspection Dwg: D3453 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



☒ First Article ☒ Prototype

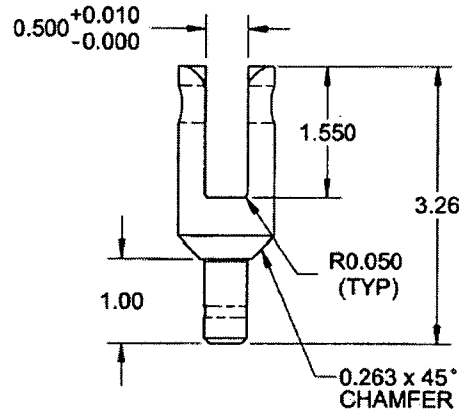
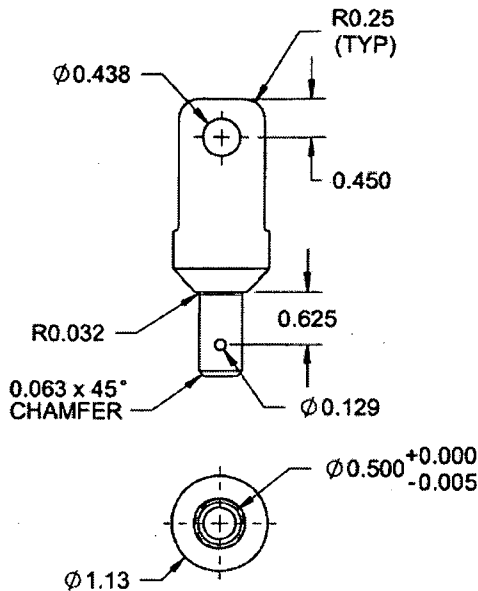
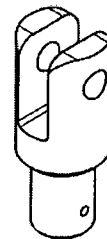
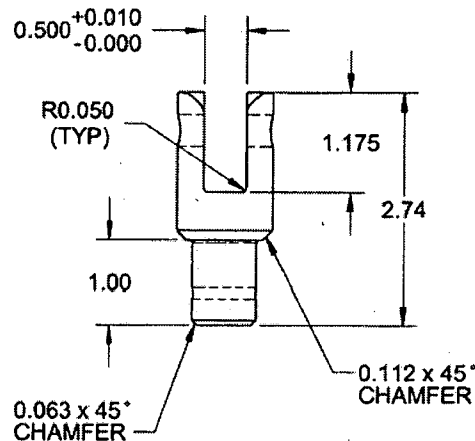
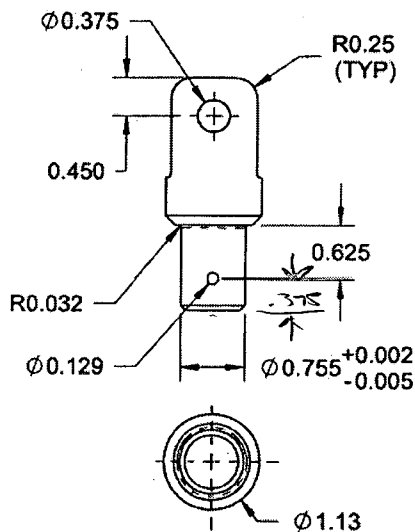

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.13	+0.030	Ø1.126	✓			
Ø0.755	+0.002 -0.005	Ø0.755	✓			
Ø0.129	±0.005 ±0.000	Ø0.129	✓			
R0.032	±0.010	R0.032	✓			
0.450	±0.010	0.454	✓			
Ø0.375	+0.005 -0.000	Ø0.379	✓			
R0.250	±0.030	R0.250	✓			
0.625	±0.010	0.620	✓			
0.500	±0.010 ±0.000	0.500	✓			
R0.050	±0.010	R0.050	✓			
1.00	±0.030	1.000	✓			
0.063X45°	±0.010	0.064X45°	✓			
0.112X45°	±0.010	0.106X45°	✓			
2.74	±0.030	2.745	✓			
1.175	±0.010	1.175	✓			

Measured by: 	Audited by: MB	Prototype Approval: 
Date: 06/01/22	Date: 06/01/22	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3453	REV. A SHEET 1 OF 2
DATE 05.09.02	TITLE CLEVIS		SCALE 1:2
A	05.09.02	NEW ISSUE	

**D3453-1 CLEVIS****RELEASED**05.12.09 **D3453-3 CLEVIS****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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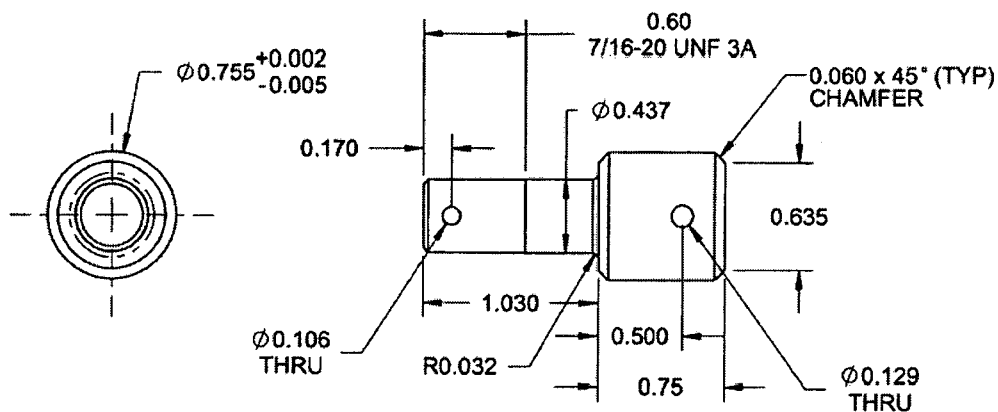
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2.81.375
2.29

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3453	REV. A SHEET 2 OF 2
DATE 05.09.02	TITLE CLEVIS		SCALE 1:1

RELEASED05.12.09 *[Signature]***D3453-5 PLUG****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC. M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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